

In the Specification:

Please rewrite paragraph [0018] as follows:

[0018] Analogous to the geometric embodiments and manufacturing steps described for Figures 1 to 3, Figures 4 to 6 show similar designs and manufacturing steps, with the specific difference that a lower circumferential shoulder is formed, in the case of the piston blank 1 below the piston crown 2. This lower circumferential shoulder 10 is located, for example, at about the level of the crown of the piston boss 4, but it can also be located above or below it. This lower shoulder 10 is also produced by forging the piston blank (Figure 4), where a recess is also subsequently introduced into the piston blank 1 (Figure 5) and the machined lower shoulder 10 is then positioned against the piston blank 1 by mechanical shaping in such a way that the cooling channel 7 is created (Figure 6). The lateral surfaces of the piston blank 1 are then machined, specifically to introduce the recesses for the ring belt 9.

Please rewrite paragraph [0019] as follows:

[0019] Finally, Figure 7 shows a piston blank 1 which has both a ~~lower upper~~ shoulder 5 and spaced apart from it a lower shoulder 10, which are produced by forging. In the area of the facing surfaces of the two shoulders 5 and 10 a radially circumferential recess is introduced into the piston blank 1 and then both the upper shoulder 5 and the lower shoulder 10 are positioned against the piston blank in the direction of the recess so that it is closed and the cooling channel 7 is created. Depending on the machining of the two shoulders 5, 10, it is conceivable that after being positioned against the piston blank 1, they make contact at their butt edges or can also overlap one another. Here too, it is conceivable that the two butting surfaces of the shoulders 5, 10 are rigidly joined (e.g. by welding).

List of reference numbers

1. Piston blank
2. Piston crown

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3. Piston skirt

4. Piston boss

5. (Upper) shoulder

6. Recess

7. Cooling channel

8. Contact area

9. Ring belt

10. (Lower) shoulder